

Date:

Tuesday, 4/18/2006 10:07:02 AM
Kim Johnston

Process Sheet

Split
06/10/24

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26690
 Estimate Number : 10420
 P.O. Number : *N/A*
 This Issue : 4/18/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL / MED FAB
 Previous Run : 24712
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.04.18
 Comment : Est: A 0408.07 New Issue KJ/JLM

Drawing Name : BRACKET ASSEMBLY
 Part Number : D3303043
 Drawing Number : D3303 REV. A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 5/20/2006

Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33031 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

PLATE

Pick:

Qty	Part Number	Description	Batch
1	D3303-1	Plate	<i>B24691</i>

2.0 D33033 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3303-3	Bracket	<i>B24692</i>

3.0 MS20426AD33 Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 56.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-3	Rivet	<i>N 7681</i>

4.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 16.0000 Each(s)/Unit Total : 112.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 02/10/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26690

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description:

16 MS20470AD4-4 Rivet

M18729

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

M18534

4 MS21075L3

Nut Plate

~~M18729~~

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

EAD

06/16/26

8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD

06/10/26

8.0

POWDER COATING

POWDER COATING



M19720



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

yl

06/10/26 x8

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC

06/10/26

7

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SD 06/10/26 7

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/27

Job Completion



U 06/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

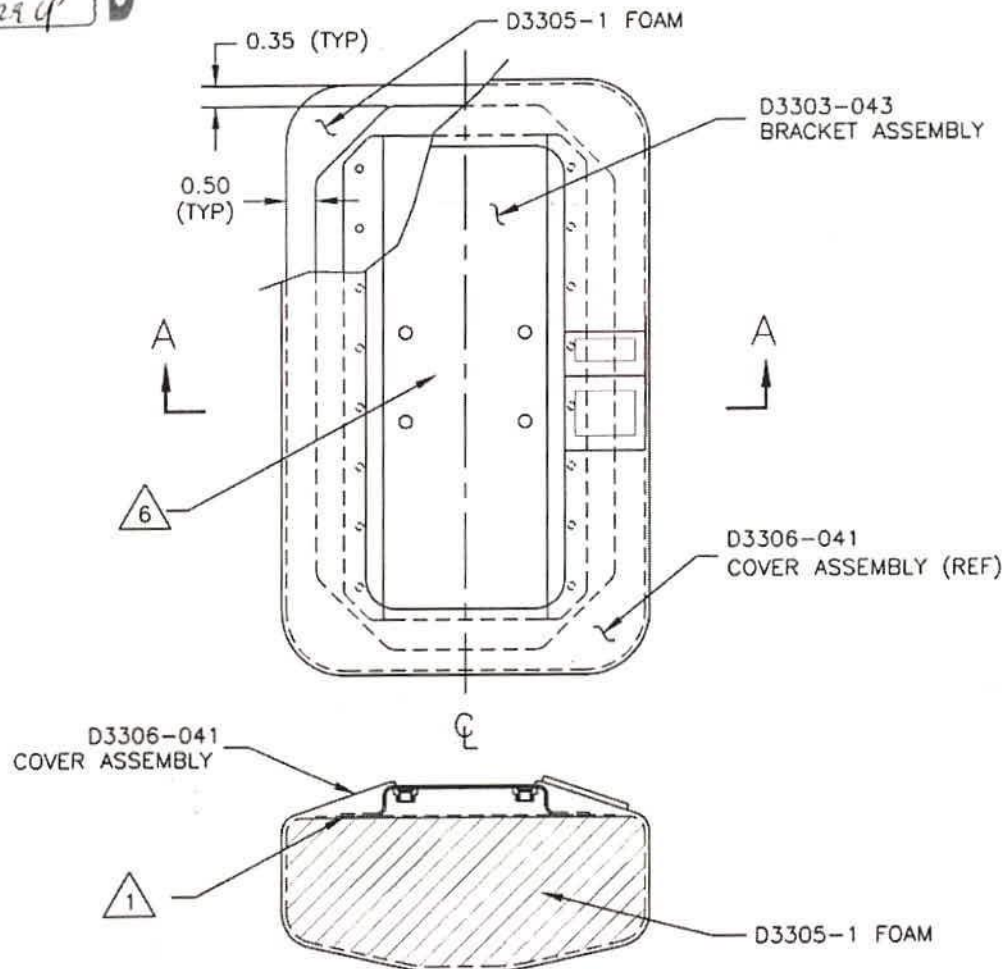
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18	TITLE HEAD REST		SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.29 6'**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

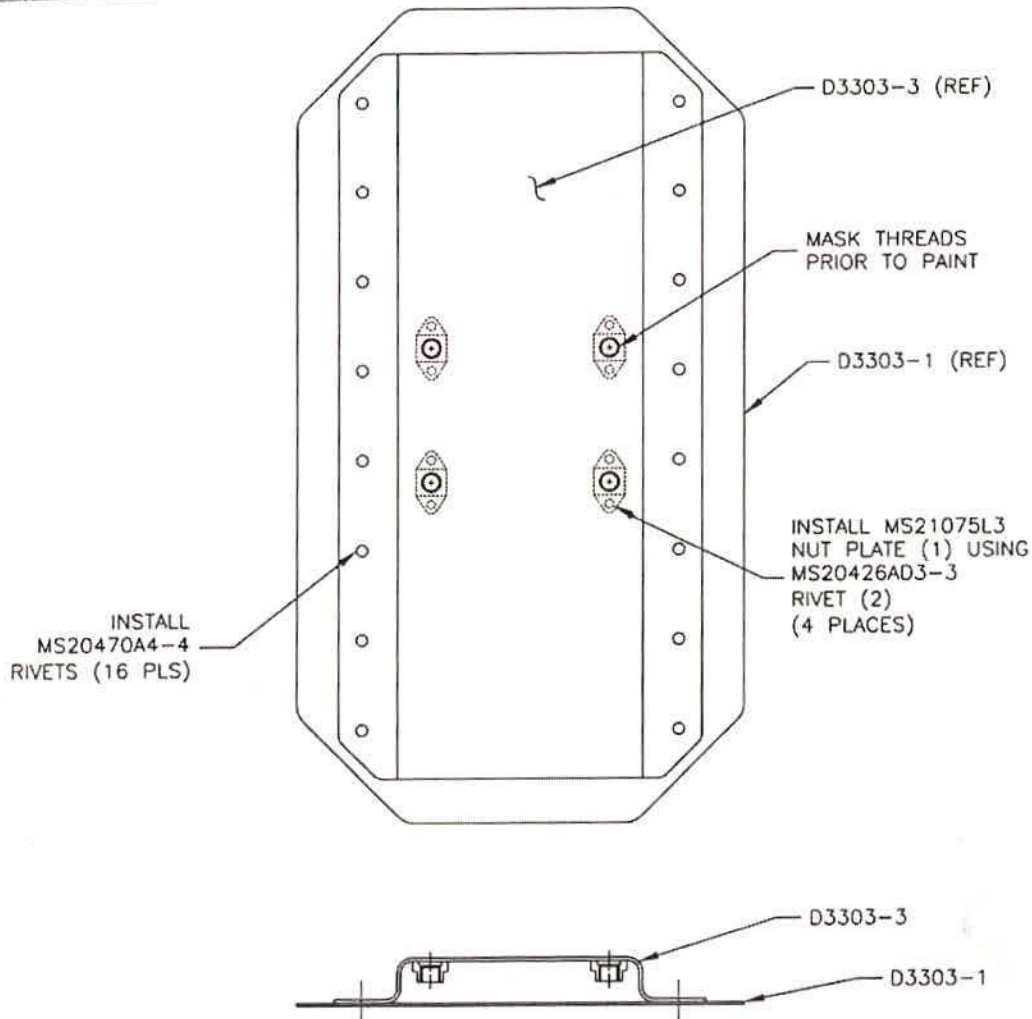
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

RELEASED
04.09.19 CP**D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

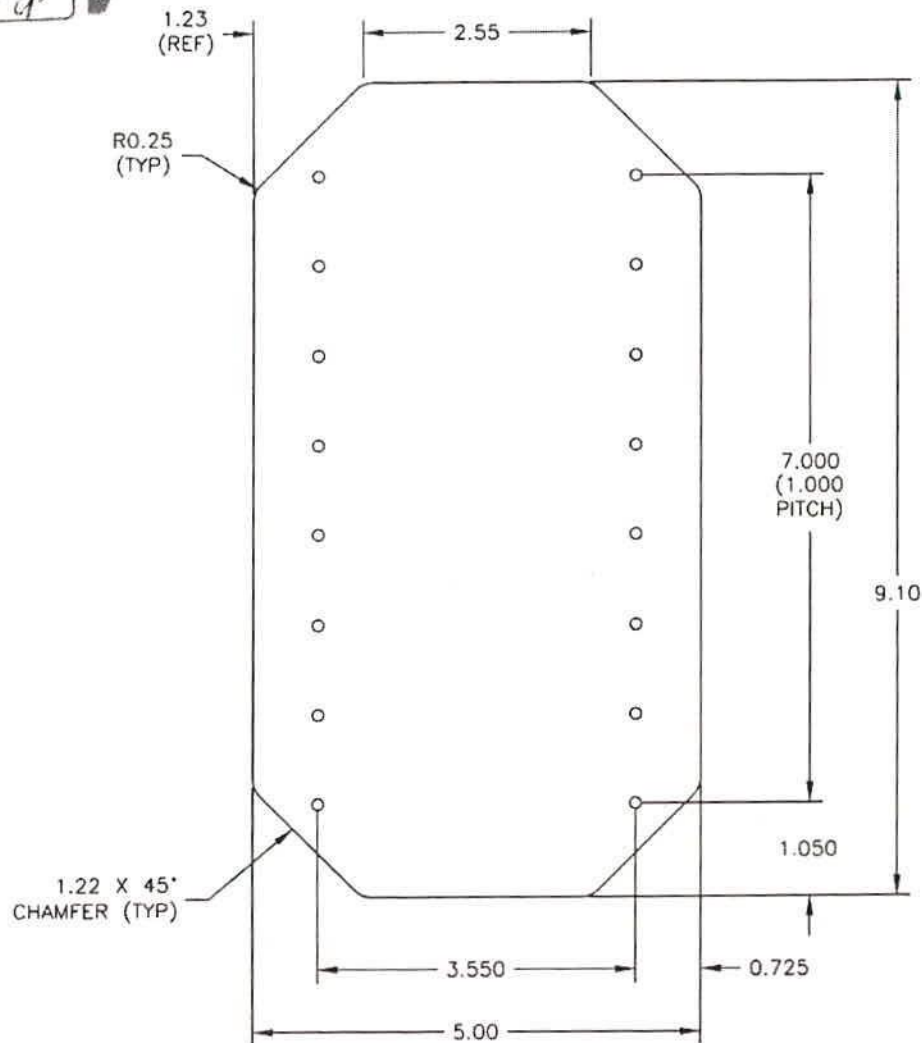
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

RELEASED
04.09.24 CP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

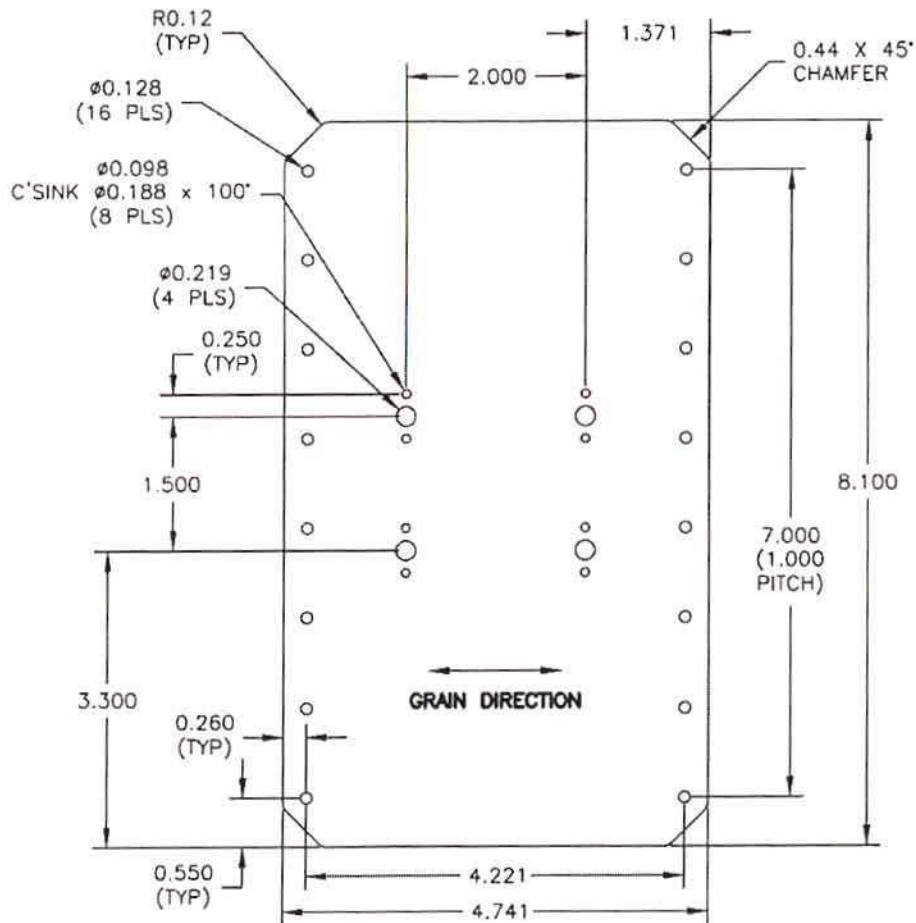
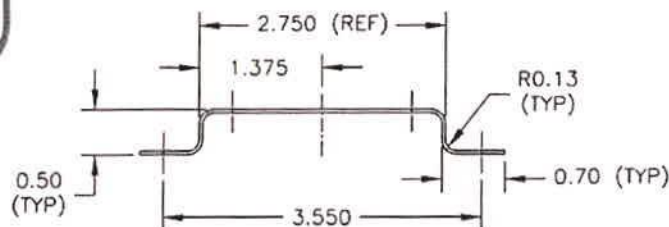
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**
04.09.29 CP**D3303-3 BRACKET
BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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